

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 82.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016653**Date Inspected:** 23-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1330**Contractor:** Westmont Industries**Location:** Santa Fe Springs, CA.

CWI Name:	Rick Rodriguez		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No N/A
Weld Procedures Followed:	Yes	No N/A
Verified Joint Fit-up:	Yes	No N/A
Approved WPS:	Yes	No N/A
Delayed / Cancelled:	Yes	No N/A

Bridge No: 34-0006**Component:** Travelers**Summary of Items Observed:**

The Quality Assurance Inspector Sean Vance arrived on site at Westmont Industries (WMI) in Santa Fe Springs, CA, to randomly observe the in process welding of the Travelers. The QA Inspector arrived on site to randomly observe the WMI Quality Control (QC) Inspectors in process and completed visual and nondestructive testing. Upon the arrival of the QA Inspector the following observations were made:

Traveler E2/E3-EB

On this date, the QA Inspector was informed by WMI Shop Superintendent, George Grayum that plate material is currently being cut, for the E2/E3-EB Traveler. Mr. Grayum informed the QA Inspector that the Pearson brand cutting shear, located in Bay # 4, is being utilized for the cutting operations and had previously explained that the shear is capable of cutting plate material, up to .500" (12 mm) in thickness.

The QA Inspector later observed WMI production personnel Mr. Ruiz Villasenor, utilizing the Pearson shear to cut plate material. Mr. Villasenor explained that he was currently cutting material, to be utilized for the fabrication of the E2/E3-EB Traveler. Mr. Villasenor explained that he has generated a material cut list, from the shop drawing Bill of Material list and is utilizing this list to cut the plate material to specific sizes, per the shop drawings.

The QA Inspector observed that the shearing or cutting of the plate material, continued throughout the shift and observed that by the end of shift, the following material was cut and identified on each piece, by Mr. Villasenor:

2 each-Reference drawing # WMI-SAS-260-Piece mark E260

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

2 each-Reference drawing # WMI-SAS-260-Piece mark D260
2 each-Reference drawing # WMI-SAS-259-Piece mark H259
2 each-Reference drawing # WMI-SAS-262-Piece mark N262
2 each-Reference drawing # WMI-SAS-262-Piece mark D262
8 each-Reference drawing # WMI-SAS-226-Piece mark DM
8 each-Reference drawing # WMI-SAS-218-Piece mark BD
2 each-Reference drawing # WMI-SAS-219-Piece mark BT

The QA Inspector also observed that the plate material, had been previously inspected by WMI QC Inspector Rick Rodriguez and that the Mill Test Report's (MTR's) had been previously provided to the QA Inspector.

The QA Inspector observed that the above mentioned material had been previously inspected by the QA Inspector and appeared to be in compliance with the contract requirements.

See attached picture below.

Material, Equipment, and Labor Tracking (MELT)

QA Inspector Sean Vance performed a verification of material, personnel and equipment involved with the project. The QA Inspector observed at Westmont Industries: 1 QC, 1 supervisor and 1 production personnel.



Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Vance, Sean	Quality Assurance Inspector
Reviewed By:	Edmondson, Fred	QA Reviewer
